

5/20

DART AEROSPACE LTD	Work Order:	23195
Description: Placard	Part Number:	D3214-1
Dwg: D3214 Rev. A1	Qty:	10

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	A	05/05/09	10
2	GA	Cut blanks: 3.70" x 2.70" Material: 5052-H32/H34 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Identify for D3214-1			
3	GA	Drill hole and fillet corner as per Dwg D3214	SP	05/06/09	10
4	GA	Deburr Identify as D3214-1	SP	05/06/09	10
5	QC5	Inspect work to Step 4	Z	05-07-05	10
6	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05-07-05	10
7	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	ML	05-07-06	10
8	QC3	Inspect Powder Coat	Z	05-07-11	10
9	MV	Engrave text as per Folio FA394 and Dwg D3214	SD	05-07-13	10
10	QC2	Inspect parts as they come off the CNC machine	SD	05-07-13	10
11	QC8	Second check	BL	05-07-13	10
12	ST	Identify and Stock	CL	05/07/14	10
13	AC	Cost / part <u>7.58</u>	HP	05/07/15	10
14	DC	Close W/O <u>8.29</u> Inspect Level 21	HP	05/07/15	10

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	✓

RELEASED

2014-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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DRAFT

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED RF	APPROVED RF	DRAWING NO. D3214
DATE 04.01.27		TITLE PLACARD
		REV. A SHEET 1 OF 1
A	04.01.27	SCALE 1:1
A1	04.05.14	CORRECT TYP: 4.3 WAS 4.1

RELEASED
04.04.05 #



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WITHOUT NOTICE

WORK ORDER
NO. 23195

NOTES

- 1) MATERIAL: 5052-H32 /H34 (QQ-A-250/8) 0.080 THICK (M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 005 4.1
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

4.3
4.1
A1

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2005
09:55 am

Work Order No	:	0023195	Department Code:		
Project Name	:	D3214-1	Burden Flags	:	NNNNNNN
Project For	:	WK520	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D3214-1	Invoice Number	:	
Description	:	Placard	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	10	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	05-05-05	Est Mark Up	:	0.000%
Est Finish Date	:	05-20-05	Actual Mark Up	:	0.000%
Act Finish Date	:				
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	
Misc.	:	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden	:	0.00	0.00	0.00	
=====		=====	=====		
Total Cost	:	0.00	0.00	0.00	
Mark up	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	0.00